

Work Order ID 56081

February 9, 2010 3:38:54 PM



Page 1

Item ID:	D3655-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	PANEL					
Start Date:	2/09/10	Start Qty: 3.00		Cust Item ID:		
Required Date:	2/19/10	Req'd Qty: 3.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date: 10-2-09	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3655	Rev B								

100		0.00							
	HAND FINISHING THERMOFORMING								
Thermoform	Memo	0.00							
Thermoforming Machine	Cut Blanks to fit frame size								

110		0.00							
	THERMOFORMING MACHINE								
Thermoform	Memo	0.00							
Thermoforming Machine	Thermoform as per Dwg. D3655-3 and Folio FTA 017 using tool DT 8985 <input type="checkbox"/> Dwg. Rev. <input checked="" type="checkbox"/> Folio Rev. <input checked="" type="checkbox"/>								

120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control	Visually inspect for proper formation of each part								

10/04/27
X5

10/04/27
X5
P.T.O. (X1) SCRAP

10/04/27
X5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3655-3 PAR #: _____ Fault Category: Then no firming NCR: Yes No DQA: [Signature] Date: 10.04.28
 Resolution: Scrap Disposition: scrap QA: N/C Closed: [Signature] Date: 10/05/04

NCR: <u>56001</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/04/27</u>	<u>110</u>	<u>First Part Toller WRINKLES IN PIECE Qty 1 panel aft A.C. process</u>	<u>[Signature]</u>	<u>LOWER TEMP 308°F-299°F in Folio Scrap 1 part & replace</u>	<u>[Signature]</u> <u>10/04/27</u>	<u>S</u> <u>Colours</u>	<u>[Signature]</u>	<u>S</u> <u>Colours</u>

NOTE: Date & initial all entries

Work Order ID 56081

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Item ID: D3655-3

Accept

Setup Start

Revision ID:

Stop

Item Name: PANEL

Start Date: 2/09/10

Start Qty: 3.00

Cust Item ID:

Required Date: 2/19/10

Req'd Qty: 3.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

HAND FINISHING THERMOFORMING

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions as per dwg D3655

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Check dimensions to ensure conformity to drawing tolerances.

10/04/28.

10/04/28

X5

10/04/28

X5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: D3655-3

Accept



Setup Start



Revision ID:

Stop



Item Name: PANEL

Start Date: 2/09/10 Start Qty: 3.00



Cust Item ID:

Required Date: 2/19/10 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	Swb6bs			(25)			
170 Packaging Packaging	Identify as per dwg & Stock Location Memo	0.00 0.00	179			105-35	(50)		
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/05/04 BS 10-5-04 (5)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

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Work Order ID: 56081



Parent Item: D3655-3

Parent Item Name: PANEL

Start Date: 2/09/10

Required Date: 2/19/10

Comments: IPP Rev. A 07/12/13 New Issue DL verified by:DD
IPP Rev. B 08/09/25 Dwg. Update DL.

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	211.4885	103.9800			



GE PLASTICS LEXAN SHEET

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

211.4884526

107574

16.62

111973

180.609853

112176

14.2586

114456

2.
3+1

10/04/27
XJ
X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	56081
Description: Panel		Part Number:	D3655-3
Inspection Dwg: D3655	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 10/04/28

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
67.9	+/-0.100	67.9	✓			
25.0	+/-0.100	25.0	✓			
44.5	+/-0.100	44.5	✓			
0.070	Min	.091	✓			
0.050	Min	.066				

Measured by: BB

Date: 10/04/28

Audited by: JK

Date: 10/04/28

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.06.11	New Issue	KJ	<u>JK</u>

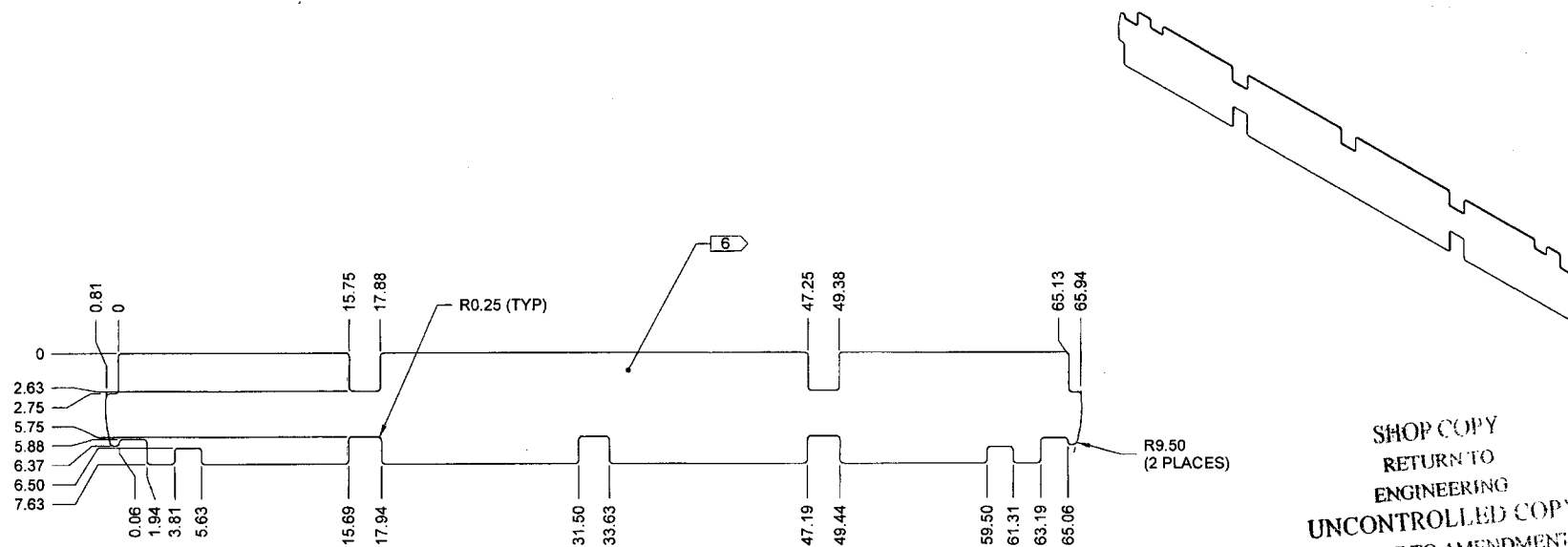
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D3655-1 PANEL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 56081
0510-209

RELEASED
08.07.30/14

D3655-1 NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 7) WEIGHT: 1.8 lbs

B	44.5 WAS 45.5 (ZN C8-2); 20.9 WAS 19.9 (ZN D5-2); DELETE REFERENCE DIMENSION 2.4 (ZN D6-2); ADD 30.25 DIMENSION FOR TRIMMING (ZN C3-2); REASON: DRAFTING ERROR	PH	08.06.16
A	NEW ISSUE	LE	08.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN	LE		
DRAWN	LE		
CHECKED	LE		
MFG. APPR.	LE		
APPROVED	LE		
DE APPR.	LE		
DATE	08.06.16		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3655 REV. B TITLE PANEL SCALE NTS SHEET 1 OF 2 <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>			

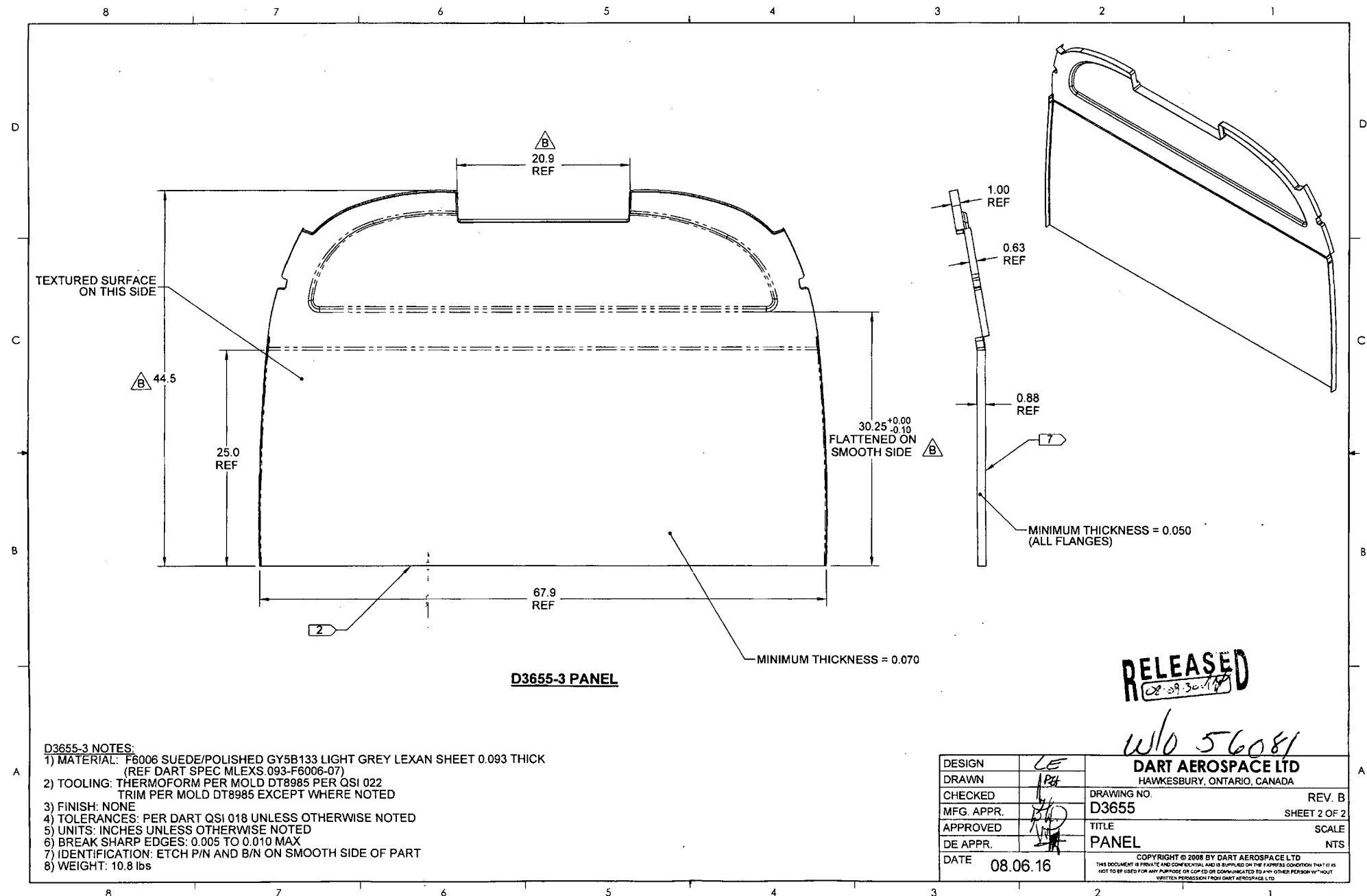
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RELEASED
08-09-30-118

W/O 56081

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	IRH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3655	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PANEL	NTS
DATE	08.06.16	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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